

Work Order ID 128247

Tuesday, January 13, 2015 1:35:40 PM

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Item ID: D4148-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Plate, Fwd
 Start Date: 1/13/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	E								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: E

Dwg Rev: E

304, 125

OPEN HOLES TO SIZE AS PER DWG

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(14)

DC 15/01/15

(14)

DC 15/01/15

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									JAN 16 2015
150	Identify as per dwg & Stock Location: SH03A	0.00							DAS 06 9-89
150									
Packaging	Memo	0.00							
Packaging									JAN 16 2015
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15/1/19

Picklist Print

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Work Order ID: 128247

128247

Parent Item: D4148-1

D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.10.29 as per revC DD verf:EC

11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	242.0000	0.3607	5			

M304S11GA

304/316 0.125 Sheet

01/15/15

Location

Loc Qty

Loc Code

MAT020

242

122521

42

M128254

64

M129545

40

M129972

96

5.3333

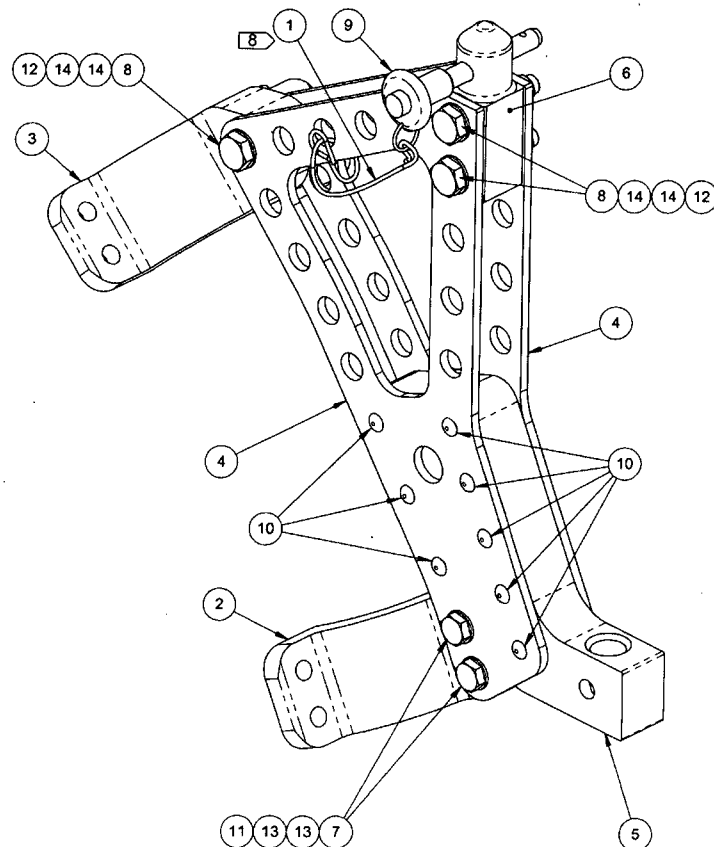
DART AEROSPACE LTD		Work Order:	128247
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.128	/		V=De-02	
Ø0.191	+0.005/-0.001	.190	/		V=De-01	
Ø0.38	+0.006/-0.001	.381	/		Tape	
Ø0.257	+0.006/-0.001	.258	/			
Ø0.50	+0.008/-0.001	.497	/			
0.94	+/-0.030	.94	/			
4.47	+/-0.030	4.471	/			
0.750	+/-0.010	.751	/			
8.47	+/-0.030	8.47	/			
8.096	+/-0.010	8.087	/			
5.43	+/-0.030	5.43	/			
5.197	+/-0.010	5.196	/			
4.733	+/-0.010	4.733	/			
0.310	+/-0.010	.310	/			
0.750	+/-0.010	.750	/			
0.375	+/-0.010	.375	/			
1.84	+/-0.030	1.84	/			
0.92	+/-0.030	.92	/			
3.000	+/-0.010	2.997	/			
0.750	+/-0.010	.750	/			
0.625	+/-0.010	.625	/			
1.982	+/-0.010	1.981	/			
0.991	+/-0.010	.991	/			
0.77	+/-0.030	.77	/			
1.54	+/-0.030	1.54	/			
2.47	+/-0.030	2.47	/			
0.82	+/-0.030	.82	/			
3.57	+/-0.030	3.57	/			
1.23	+/-0.030	1.23	/			
0.73	+/-0.030	.746	/			
0.125	+/-0.010	.117	/			
Ø0.252	+0.003/-0.000	.253	/			

Measured by: DC	Audited by: 38	Preliminary Approval:
Date: 15/01/15	Date: 9-89	Date:
	5106 91 NVT	
	JAN 16 2015	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	
F	13.11.26	Dwg Rev updated	KJ	



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.66 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIN, QUICK RELEASE
10	8	MS20615-4M18	RIVET, SOLID, PAN-HEAD
11	2	MS21043C3	NUT, SELF-LOCKING
12	3	MS21043C4	NUT, SELF-LOCKING
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

SHOPELBY
RETURN TO
ENGINEERING
FOR CONTROL AND COPY
SUBJECT TO AGREEMENT
WITH OFFICE
WORK ORDER
NO. 128247 MCT
15-01-14

RELEASED
2013-08-16
MP

E	B6-4 Ø0.268 HOLE ADDED FOR CARGO TUBE INSTALLATIONS.	AJS	13.07.22
D	HOLE DIA CHANGED TO 0.252" (D6-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18

REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. E
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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8 7 6 5 4 3 2 1

D

C

B

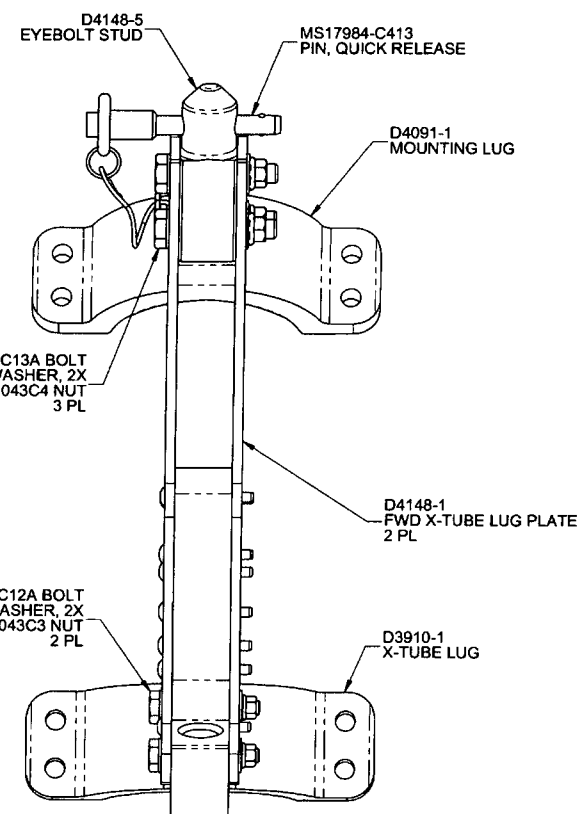
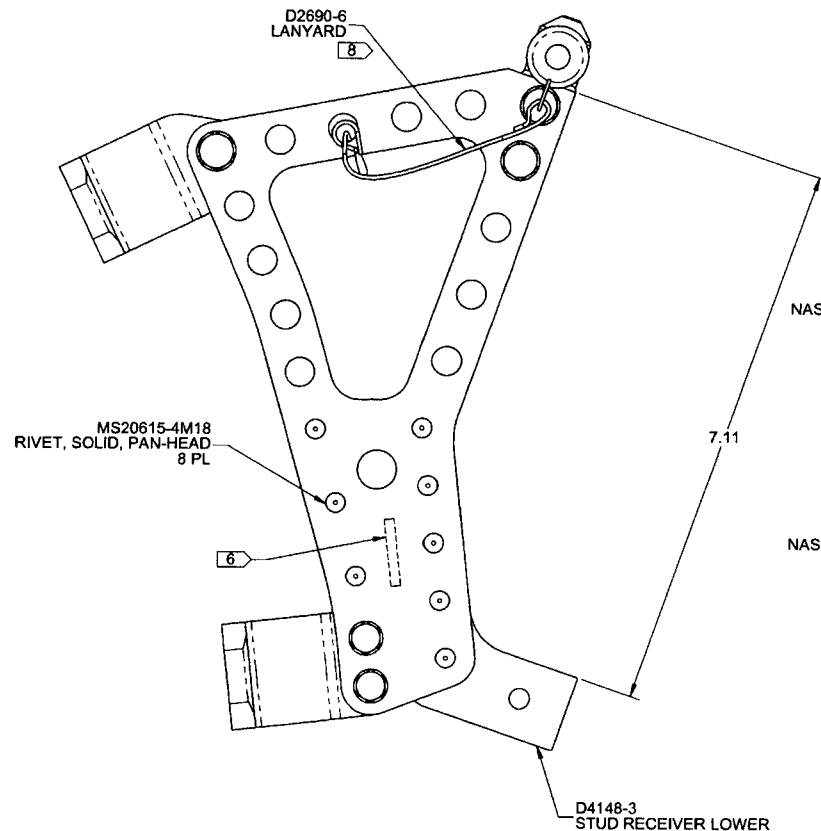
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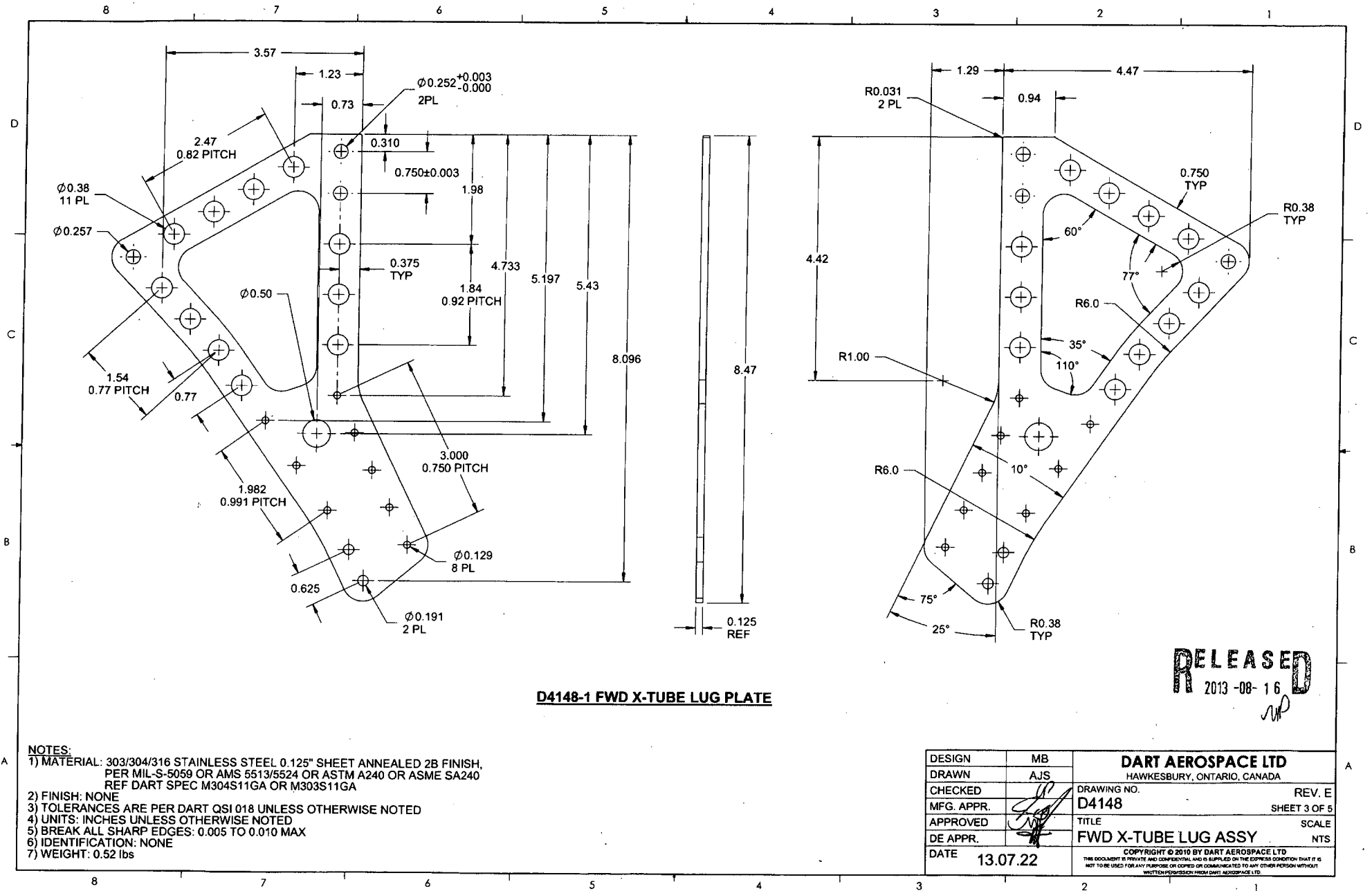


D4148-041 FWD X-TUBE LUG ASSY

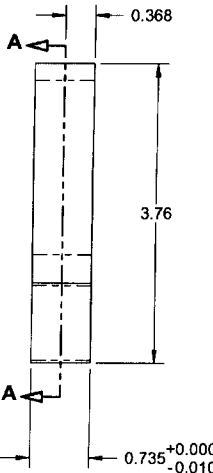
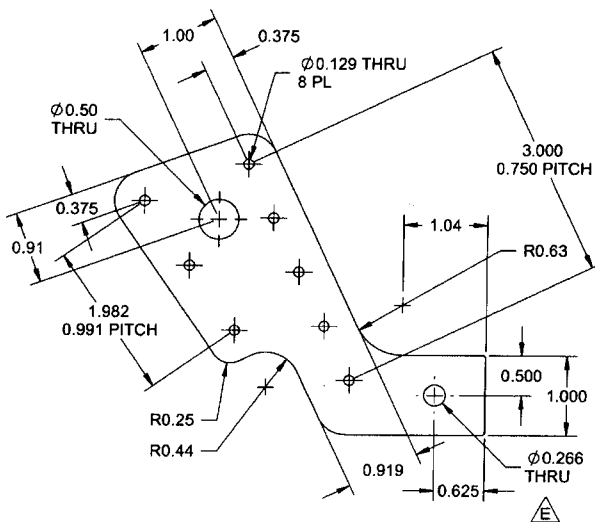
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2013-08-16
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D4148	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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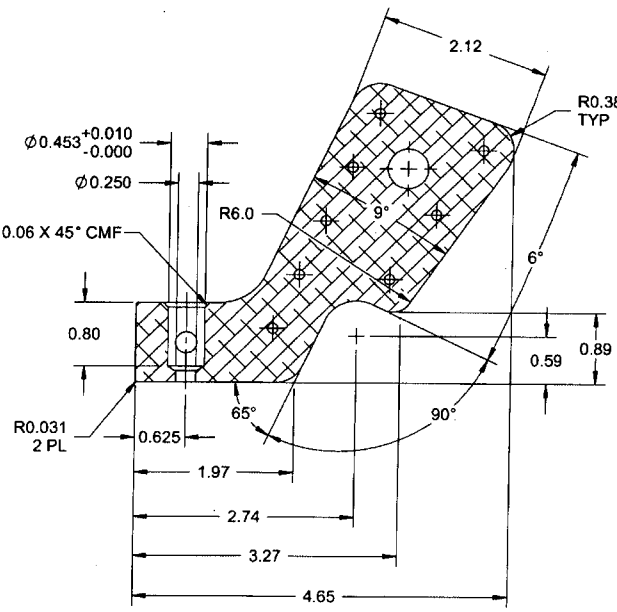
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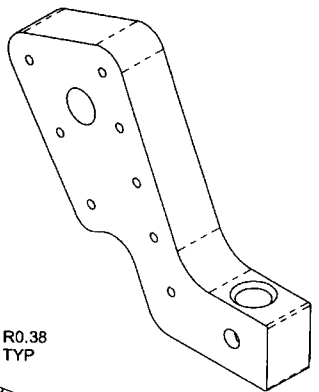
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D4148-3 STUD RECEIVER LOWER



SECTION A-A

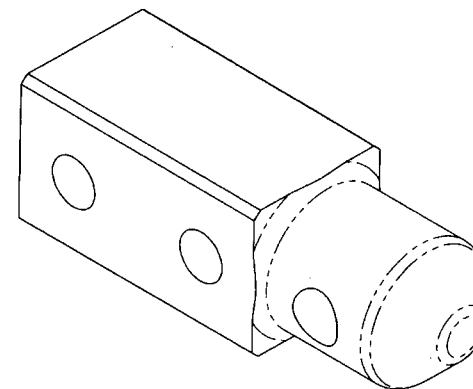
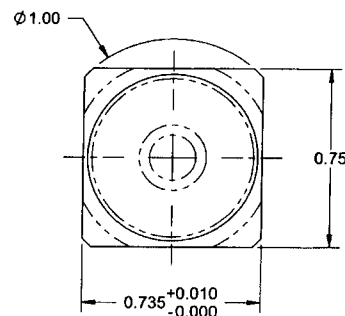
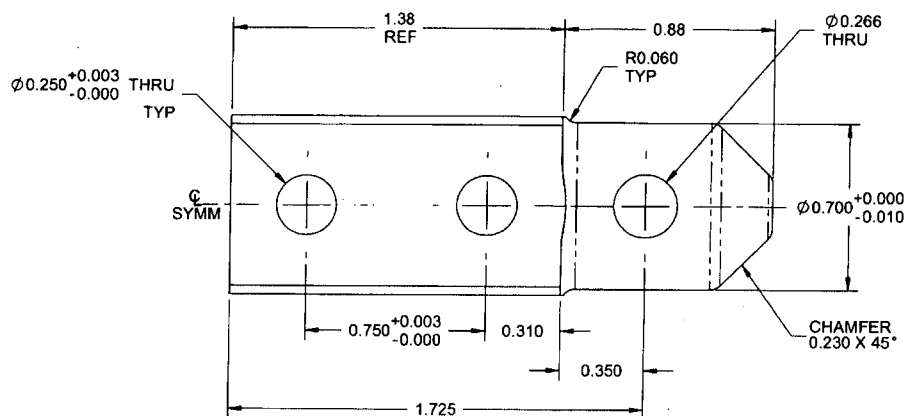


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2013-08-16

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276 REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.51 lbs

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MFG. APPR.		D4148	SHEET 4 OF 5
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8 7 6 5 4 3 2 1



D4148-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

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